

**Work Order ID 66767**

Saturday, February 26, 2011 9:12:54 AM

**PRELIMINARY ISSUE**

Page 1

Item ID: D4322-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Spacer

Stop



Start Date: 2/28/2011 Start Qty: 15.00



Cust Item ID:



Required Date: 3/3/2011 Req'd Qty: 15.00



Customer:

Reference: *11-02-26*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4322

PA1

*11-02-26**A-10*

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg and Folio FB039

2-Break all sharp edges 0.010 max.

*11/2/28*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11/2/28*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control





*11/2/28*

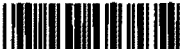

**Work Order ID 66767**





Saturday, February 26, 2011 9:12:54 AM



Page 2

Item ID: D4322-3      Accept            Setup      Start        
Revision ID: PRELIM      Stop        
Item Name: Spacer  
Start Date: 2/28/2011      Start Qty: 15.00            Cust Item ID:  
Required Date: 3/3/2011      Req'd Qty: 15.00            Customer:  
Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run      Start        
QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
			⇒ m-11/02/28						
									
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
			15 BR 11-2-28						
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>Preh Shelf</i>  Memo	0.00  0.00							
			15 <i>Preh</i> 11-03-01						
			PAGE 4 <i>Preh</i> 11-03-01 (3)						

**Work Order ID 66767**

Saturday, February 26, 2011 9:12:54 AM

Page 3

Item ID: D4322-3

Accept

Revision ID: PRELIM

Item Name: Spacer

Start Date: 2/28/2011 Start Qty: 15.00

Required Date: 3/3/2011 Req'd Qty: 15.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10

CL 11/03/01

R2370-MAR

POSITIVE RECALL

EFFECTIVE 11/23/06 AUTH

RELEASED DATE 11/05/12

# Picklist Print

Saturday, February 26, 2011 9:12:50 AM

Page 1

Work Order ID: 66767

Parent Item: D4322-3

Parent Item Name: Spacer



Start Date: 2/28/2011

Required Date: 3/3/2011

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A NEW ISSUE 11-02-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased		No			f	27.6140		1.091053			
ROUND BAR 1.00"													

Location

Loc Qty

Loc Code

MAT

25.434

115609

1.434

116406

24

MAT013

2.18

108876

1.88

113457

0.3

5/11/2/25

1.204

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	
Date:	<i>11/2/26</i>	Date:	<i>11/02/26</i>	Date:	

*to P&J Day*

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

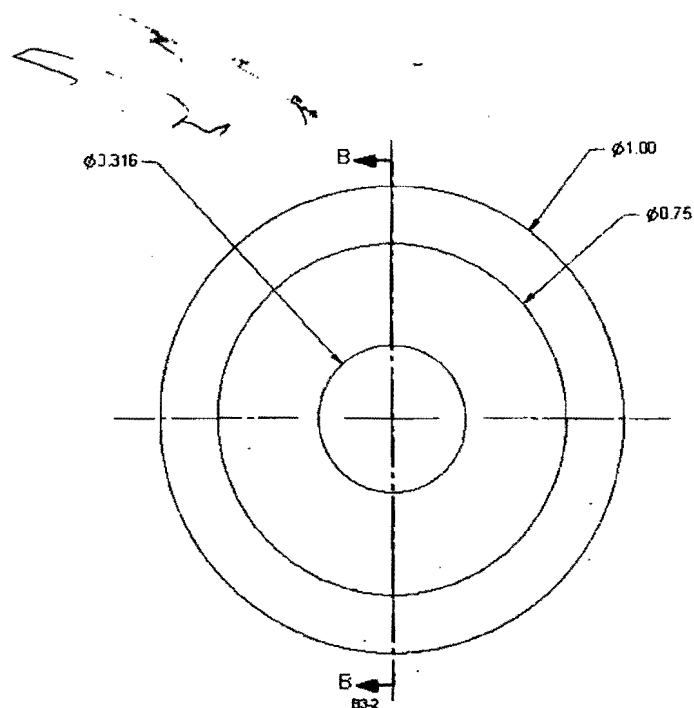
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D

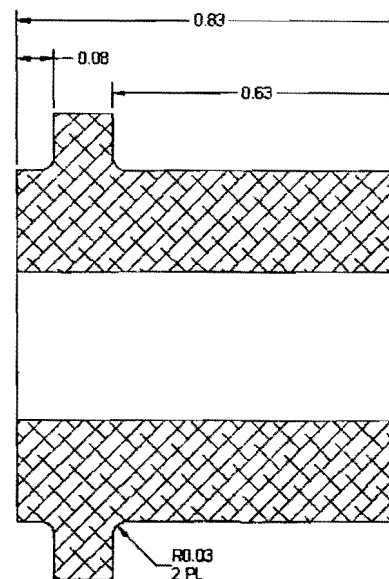
C

B

A

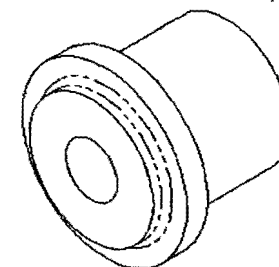


**D4322-3 SPACER**



→ | < .120

**SECTION B-B**  
**SCALE 4X** B6-2



D

C

B

A

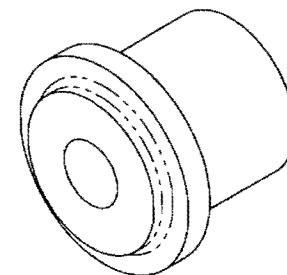
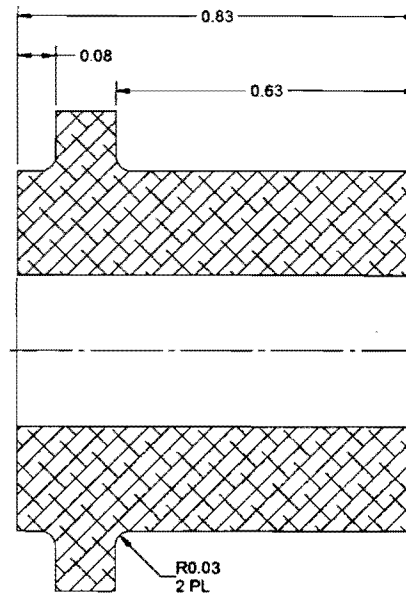
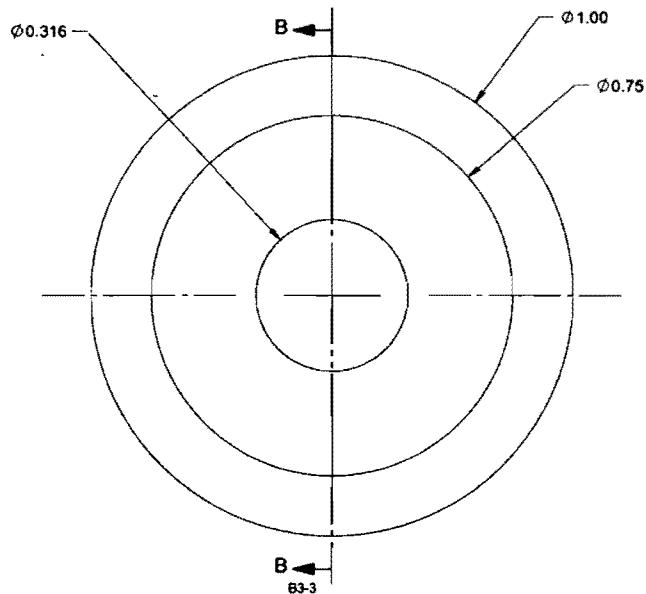
**PRELIMINARY  
ISSUE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
REF DART SPEC M6061T6R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	<b>D4322</b>	<b>DART AEROSPACE LTD</b> 144 KESSBURY, ONTARIO, CANADA	
DRAWN	<b>JE</b>	DRAWING NO.	REV: PA2
CHECKED	<b>JE</b>	<b>D4322</b>	SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED	N/A	<b>SPACER</b>	NTS
DE APPR.	N/A		
DATE	<b>11.01.13</b>	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED AND NOT FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



**D4322-3 SPACER**

**SECTION B-B**  
**SCALE 4X** B6-3

66767

**RELEASED**  
2011-05-10

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
REF DART SPEC M6061T6R1.000
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DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	<b>D4322</b>	SHEET 3 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	<b>SPACER</b>	NTS
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